Stop 52 31

## Work Order ID 111430

\*111430\*

Page 1

January-27-14	10:01:22 AM											
Item ID: Revision ID:	D3655-1			Accept	*N90	0040	100	<b>)*</b> s	etup Star	1.71	S1*	
Item Name:	Panel								Stop	*N	S2*	٠.
Start Date:	15/01/2014	Start Qty: 2.00	*	2*	Cust Ite	m ID:						
<b>Required Date:</b>	31/01/2014	Req'd Qty: 2.00		2*	Custom							
Reference:												
Approvals:	Process Pla	nn:	Date:	Tooling:		Date:		R	Run Star	~1 <i>\</i> J	R1*	
:	QC:		_ Date:	<b>SPC</b> (Y/N):		Date:			· Stop	, *N	R2*	
Sequence ID/ •Work Center II	)	Operation Description		Set Up/ Run Hour	Tool I	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	. •
Draw Nbr	Rev	vision Nbr										
D3655	Rev	В										
100			***	0.00								_
*100*		FLOW WATER JET						2		· /u	1-1-24	/ ;
Waterjet		Memo		0.00								-
FLOW CNC Waterjo	et	1-Cut as pe Deburr if n	er Dwg D3655 eccessary	Dwg Rev:Prog Rev:_								
110		QC2- Inspect parts off	machine FAI/FAI	В 0.00								
*110*									EZ	14-	1-28	
QC (		Memo		0.00								
Quality Control												
120		QC8- Inspect parts - se	cond check	0.00	AS 27 -89			7				
*120* QC Quality Control		Мето		o.oo 141	1128			<u>5</u>				

DQA: Date:				WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:		'	Date:						MINIAINCE / O		Vork Order u	odate only	AEROSPACE
Work Orde	or.	•				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N	 No					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	-				Desci	ription of work order update		nitial	Ac	tion	Sign &		T
Cause		ate	Step	Qty		or non-conformance		ief Eng		ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved						·			,				
							FAL	JLT CAT	EGORY				
Landir	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Folio/Program Grain Hardware Inspection Incomplete/Unqualifie Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration		· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other			
	_		ist in Tub	e	<b>—</b>	Fit/Function	_	ĺ	equence				

**Quality Control** 

W	ork	Order	ID	111430
<b>V V</b>	M IU	Oluci	<b>1</b>	111430

\*111430\* Page 2 January-27-14 10:01:22 AM Accept Item ID: D3655-1 \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Panel Start Qty: 2.00 \*2\* **Start Date:** 15/01/2014 **Cust Item ID: Required Date: 31/01/2014** Req'd Oty: 2.00 \*9\* **Customer:** Reference: Start Run Date: Tooling: **Approvals:** Process Plan: Date: Stop QC: Date:\_\_\_\_\_ SPC (Y/N): Date: Operation Sequence ID/ Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. Stamp DAS Work Center ID Description Qty Qty Number **Run Hours** Code 130 0.00 Identify as per dwg & Stock Location: \*130\* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 MLJ 1401-29 MLJ 1401-29 \*1//0\* OC 0.00 Memo

DQA:	Date:				WORK ORDER NON-CONFORMANCE / UPDATE								TRAC
QA Closed:		Date:			WORK ORDER NON-	-C(	JINFOI	RIVIAINCE / U		Vork Order u	odate only	$\neg$	AEROSPACE
Work Orde	or.				DISPOSITION				AGAINST D	DEPARTMENT/PROCESS			
Part N	lo.				Rework Scrap Use-as-is Suspected Unapproved			Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
		T										<u> </u>	
Root Cause	Date	Step	Qty	Desci	ription of work order update or non-conformance		Initial iief Eng	i e	tion .	Sign &	Vorification		OC Inchestor
Design	Date	Step	Qty		or non-comormance	CII	ner eng	Descr	ription	Date	Verification	+	QC Inspector
Doc/Data													
Equip/Tooling	-												
Handling/Pre													
Material													
Operator	<b>-</b>												
Offset/Setup													
Process													
Supplier													
Training													
Transport													
Unapproved													
		•	·			FAI	ULT CAT	EGORY	•••		<u> </u>		· · · · · · · · · · · · · · · · · · ·
Landir	ng Gear				General	-							
[	Bending				Bend		Folio/P	rogram	Г	Outside Dim	ensions [	T <sub>P</sub>	ressure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	<b>⊢</b>	_	et-up
	Cracks				Broken/Damage/Defect		Hardwa	re	-	Part Incorre	<b>⊢</b>	—	emperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Ur	nqualified	Part Lost/Mi	issing	_	Veld
	Cuffs	•			Contamination		Instruct	ions Incomplete/L	Jnclear	Part Moved		_	Vrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong		· ·
	Heat Trea	at			Cut Too Short		Mislabe	led		Power Loss/	Surge [	$\neg_{\circ}$	ther
	Inspectio	n Strip in	Tube		Drawing		Misread	1	_	_	, <u> </u>		· · · · · · · · · · · · · · · · · · ·
	Marks/Ch	atter			Drill Holes		Off-set						
	Turning S	equence			Finish		Out of (	Calibration					
	Wave/Tw	ist in Tub	e		Fit/Function		Out of S	equence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Page 1

Work Order ID: 111430

\*111430\*

Parent Item:

D3655-1

\*D3655-1\*

Parent Item Name: Panel

**Start Date:** 15/01/2014

**Required Date: 31/01/2014** 

Start Qty: 2.00

Required Qty: 2.00

**Comments:** 

Ext. Rev. A 07/12/13

IPP Rev:B

08-03-06 prototype DD verified by:EC DD verified by:EC

IPP Rev:C 08-04-07 revA

IPP Rev. D 08/08/16 Dwg. Update. DL

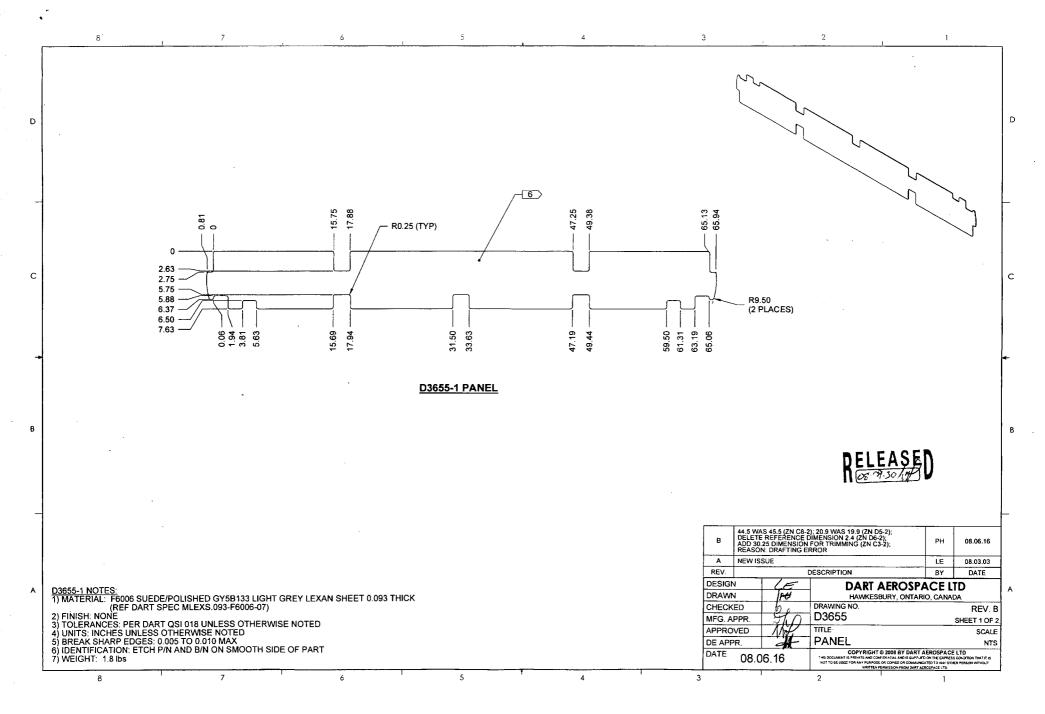
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty		Date Issued	Status
MLEXS.093-F6006-07		Purchased	No		100	sf	1,552.260	3.5366	8			
*MI FXS 0	193-F60	<b>06-07</b> *						**	EZ	141.2	18	

## 'IVII EXS 093-F6006-07

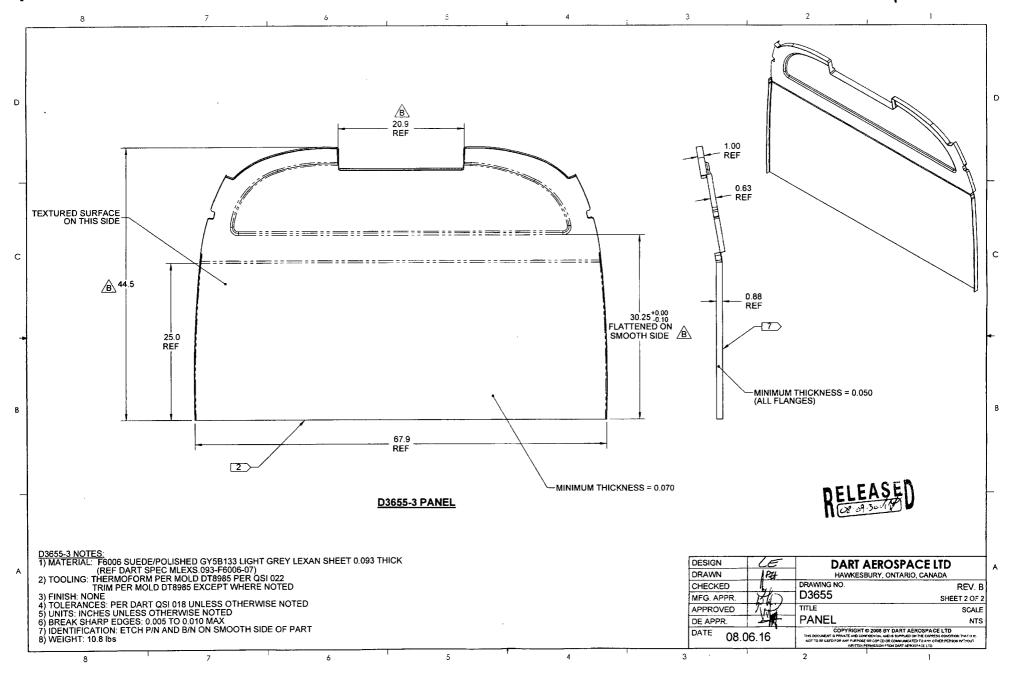
GE PLASTICS LEXAN SHEET

<b>Location</b>	Loc Qty	Loc Code	
MAT023	1552.26		
114459	229.26		
<u>123105</u>	38		
24501	1285		13.5

DQA:	QA: Date:													
01.0		Data			WORK ORDER NON	-C	ONFO	RMANCE / UI	PDATE					AEROSPACE
QA Closed:		Date	:	_			r			W	ork Order up	date only		
Work Orde	r:	:			DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
					Rework	]	Skid-tube Crosstube			Water Jet			Engineering	
Part N	0.				Scrap		Machining Small Fab		_	Pro	d. Eng. Coor.		Quality	
					Use-as-is		Thern	noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite			Supplier		
Root			T	Desc	ription of work order update	Τ	Initial	Act	ion		Sign &		$\overline{}$	
Cause	Da	te Step	Qty	0000	or non-conformance	1	nief Eng	1	iption		Date	Verification	,	QC Inspector
Design		to stop.	1 2.7		or non comotinance	+	iici Liig	Descr	iption		Date	vermeation	+	QC IIISPECTOI
Doc/Data					•						:			
Equip/Tooling				ļ							-			
Handling/Pre														
Material														
Operator														·
Offset/Setup														1
Process													.	
Supplier														,
Training														
Transport					•									
Unapproved														
						FA	ULT CAT	FEGORY					•	
Landin	ig Gear	•			General		_							
	Bend	ing			Bend		Folio/F	rogram			Outside Dim	ensions	P	ressure/Forced
	Centr	e Not Conce	entric		BOM/Route		Grain				Over/Under	tolerance	S	et-up
	Crack	is .			Broken/Damage/Defect		Hardwa	re			Part Incorred	et [	Т	emperature/Cure
	Crim	o/Kink/Rippl	e/Wave	Ŀ	Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	$\neg$	Veld
	Cuffs			L	Contamination		Instruct	ions Incomplete/L	Inclear		Part Moved		v	Vrong Stock Pulled
ļ	Crush				Countersink		Misalig	ned/off center			Positioned <b>V</b>	_		
1	_	Treat			Cut Too Short		Mislabe	eled			Power Loss/:	Surge		Other
1	<del></del>	ction Strip ii	n Tube		Drawing		Misread	d						
].	_	s/Chatter		<u> </u>	Drill Holes		Off-set							
ļ		ng Sequence			Finish		Out of (	Calibration						
	Wave/Twist in Tube				Fit/Function		Out of	Sequence						



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DART AEROSPACE LTD	Work Order:	11/450
Description: Panel	Part Number:	D3655-1
Inspection Dwg: D3655 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype									
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments		
1.94	+/-0.030	1.94	/	<del></del>	T Stmo6				
3.81	+/-0.030	3.81			1 0 0				
5.63	+/-0.030	5.63							
15.69	+/-0.030	15.67	/						
15.75	+/-0.030	15.75	7						
17.88	+/-0.030	17.88	/				W. V.		
17.94	+/-0.030	(7.94	V						
31.50	+/-0.030	31.50							
33.63	+/-0.030	33.63							
47.25	+/-0.030	47.25	/						
47.19	+/-0.030	47.19	7						
49.38	+/-0.030	49.38	7						
49.44	+/-0.030	49.44	,/						
59.50	+/-0.030	59.5	/						
61.31	+/-0.030	61.31							
63.19	+/-0.030	63.19							
65.06	+/-0.030	65.06							
65.13	+/-0.030	65.13							
65.94	+/-0.030	65.97	/						
2.75	+/-0.030	2.75							
5.75	+/-0.030	5.75	7						
5.88	+/-0.030	5-88							
7.63	+/-0.030	7.625							
		<u> </u>							
		<u></u>		DAS					
easured by:	a	Audited by		27	Prototype App	roval:	N/A		

Measured by:	a	Audited by:	27	Prototype Approval:	N/A
Date:	14-1-28	Date:	14/1120	Date:	N/A

Rev	Date	Change	Revised	by	Approved	4
Α	08.04.17	New Issue	KJ/DD	Δ_		
В	09.09.15	Dimensions updated per Dwg Rev B	KJ 4	3	MA	
<u></u>			•	O	,	•